

Date: Tuesday, 07/11/2006 11:35:00 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FUEL PURGE CANISTER
Job Number	: 28225		
Estimate Number	: 10440		
P.O. Number	: <i>plm</i>	Part Number	: D3262041
This Issue	: 07/11/2006 S.O. No. : <i>plm</i>	Drawing Number	: D3262 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 17/08/2006 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 26761	Material	: <i>plm</i>
Written By	: _____	Due Date	: 10/09/2006
Checked & Approved By	: _____	Qty:	8 Um: Each
Comment	: Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	28225A	FUEL PURGE CANISTER
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Comment: Sub-Component FUEL PURGE CANISTER  
D3262-1

*B26416A-2*  
*B26492-6* *RE. 06.11.7* *8*

2.0	28225B	FUEL PURGE CANISTER
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Comment: Sub-Component FUEL PURGE CANISTER  
D3262-3

*B 22032=1*  
*B 22506=14* *RE. 06.11.7* *8*

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld canister assembly as per Dwg D3262 using DT8739 to align fillings

Pick:	Qty	Part Number	Description	Batch
A/R		Aluminum Rod	<i>m19662</i>	<i>m18838</i>

*RE. 06.11.9* *8*

4.0	QC5/9	WELD INSPECTION
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Comment: WELD INSPECTION  
Pressure test as per Dwg D3262

*11/06/11/17* *(7)*  
*QC5/11/06/11/17* *(PTO)*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

*See*  
*w/o*  
*↑*

Date: Tuesday, 07/11/2006 11:35:00 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 28225

Part Number: D3262041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

1-Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

2-Ensure to mask threads

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: \_\_\_\_\_

9.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



See  
Attached  
w/o  
✓

PTC  
✓

Date: Thursday, 17/08/2006 3:29:12 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FUEL PURGE CANISTER  
 Job Number : 28225  
 Estimate Number : 10440  
 P.O. Number :  
 This Issue : 17/08/2006 S.O. No. :  
 Prsht Rev. : NC Part Number : D3262041  
 Drawing Number : D3262 REV B  
 Project Number : N/A  
 Drawing Revision : B  
 First Issue : / / Type : MACHINED PARTS  
 Material :  
 Previous Run : 26761 Due Date : 10/09/2006 Qty: 8 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est. C0503.10 Removed P/O for liquid penetrant inspection K  
 J/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 28225A FUEL PURGE CANISTER



Comment: Sub-Component FUEL PURGE CANISTER

2.0 28225B FUEL PURGE CANISTER



Comment: Sub-Component FUEL PURGE CANISTER

3.0 D32621 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Tube

Pick:

Qty

Part Number

Description

Batch

1

D-3262-1

Tube

3

26492 = 6

115362

26416A = 2

PE. 06. 11. 7

4.0 D32623 Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Cap

Pick:

Qty

Part Number

Description

Batch

2

D3262-3

Cap

3

22506 = 14

322339 = 1

822032A = 1

PE. 06. 11. 7

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

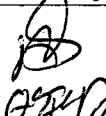
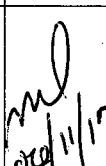
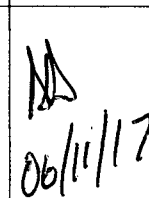
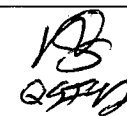
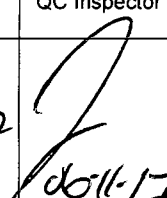
Weld canister assembly as per Dwg D3262 using DT8739 to align fillings

Pick: Qty Part Number Description Batch

PE. 06. 11. 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/11/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/17	30	1 part + SCRAP. Threads in 1 cap are completely stripped.		SCRAP: destroy.	 06/11/17	 06/11/17	 06/11/17	 06/11/17

NOTE: Date & initial all entries

Date: Thursday, 17/08/2006 3:29:13 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 28225

Part Number: D3262041

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R

Aluminum Rod

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

Pressure test as per Dwg D3262

*2011/17 (7)*

*06/11/17 (7)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*FC yl*

*06/11/20 x7*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

2-Ensure to mask threads

*FC 06 11 21 (7)*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*06/11/22 (7)*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: *ST103*

*06/11/22 (7)*

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/11/22 (7)*

Job Completion



*U 06/11/22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

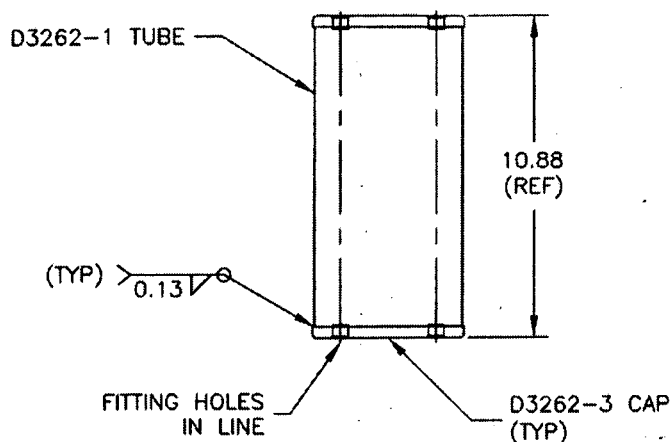
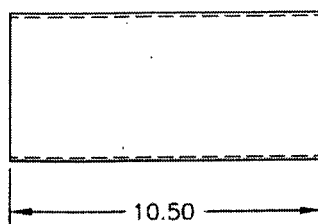
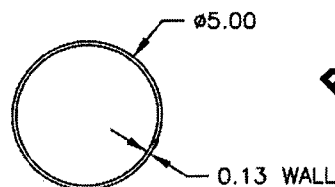
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

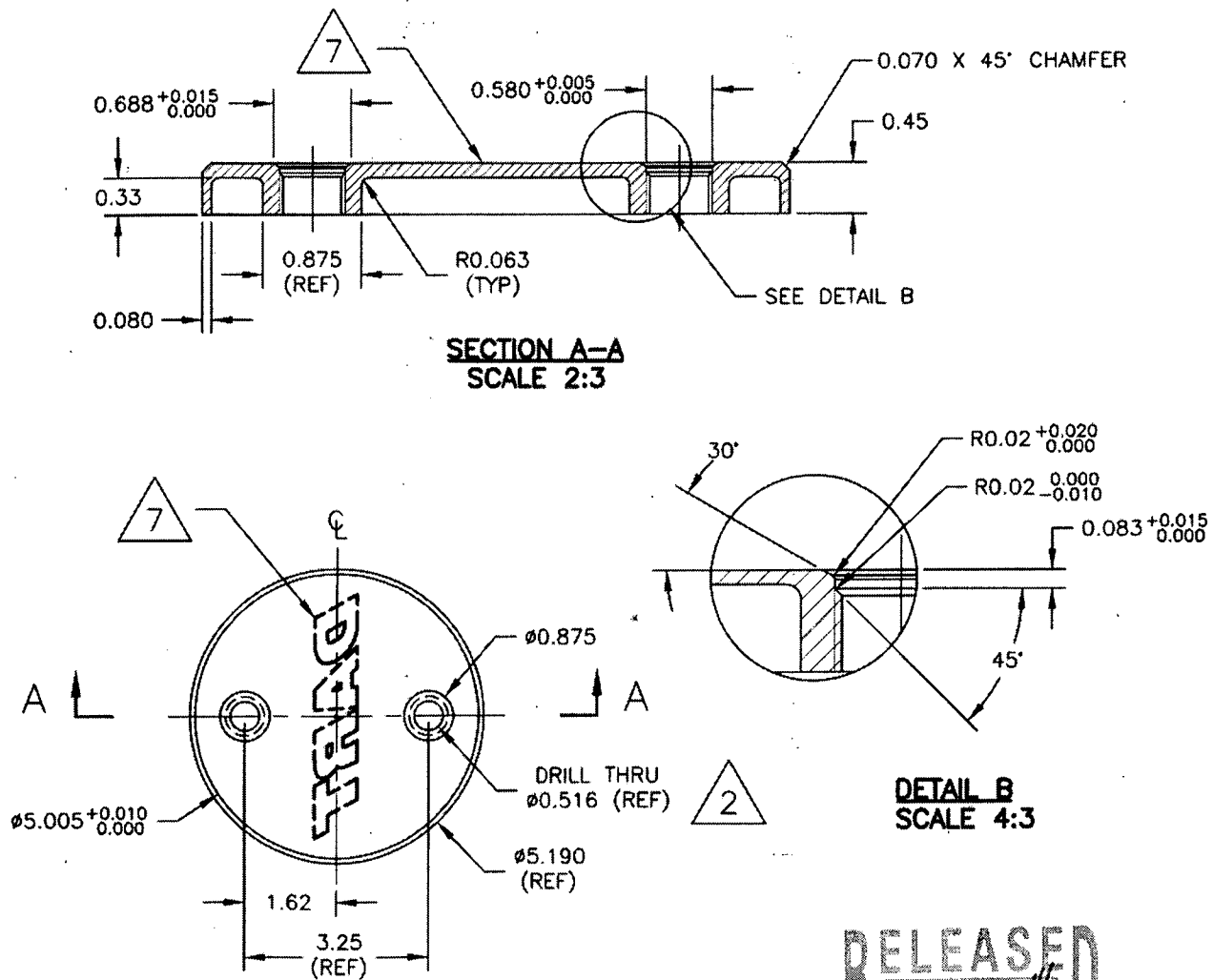
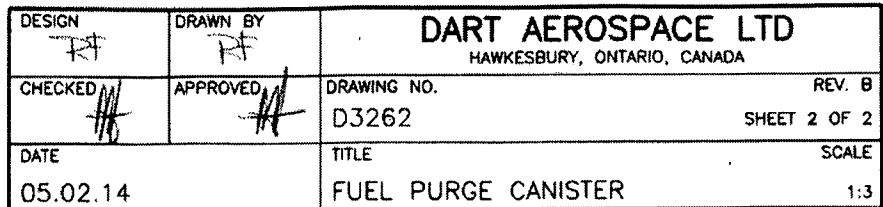
DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3262	REV. B SHEET 1 OF 2
DATE 05.02.14		TITLE FUEL PURGE CANISTER	SCALE 1:1
A	04.05.06	NEW ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	

**RELEASED**  
05.02.14**D3262-041 CANISTER ASSEMBLY****1 D3262-1 TUBE****REFERENCE ONLY****D3262-041:**

- 1) MATERIAL: 6061-T6 (WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8)  
TUBING 5.00 OD x 0.125 WALL (6061T6T5.000W.125)
- 2) WELD PER QSI 004.
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi  
AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

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D3262-3 CAP

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR  
(REF. DART SPEC. M6061T6B)

2) TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

5) BREAK ALL SHARP EDGES 0.005 TO 0.010

6) PART IS SYMMETRIC ABOUT CENTERLINE

7) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP  
(MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

RELEASED  
05.02.14

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